

Date: Tuesday, 16/12/2008 2:12:20 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : MIRROR BRACKET
Job Number : 44122A	
Estimate Number : 10148	
P.O. Number :	Part Number : D2161205
This Issue : 16/12/2008 S.O. No. :	Drawing Number : D2161 REV B2
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B2
Previous Run : 41316A	Material :
Written By :	Due Date : 22/12/2008 Qty: 4 Um: Each
Checked & Approved By : <u>JUD 08 12 16</u>	
Comment : Est Rev:A New Issue 05-11-01 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	44122A01	MIRROR BRACKET LH
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Cpl 09.04.14



Comment: Sub-Component MIRROR BRACKET LH

1 x D2013-1 Batch B36950 → ~~1 B36938~~ → B41316A01 → 23

2.0	44122A02	MIRROR BRACKET RH
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Comment: Sub-Component MIRROR BRACKET RH

1 x D2013-2 Batch B41316A02

Cpl 09.04.14

3.0	44122A03	ARM
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Comment: Sub-Component ARM

1 x D2037-101 Batch B46161C

Cpl 09.04.14

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Assemble on Jig DT8065 as per Dwg D2161

2-Weld as per Dwg D2161 Identify as D2161-205

Cpl 09.04.14

(4)

5.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

PD 09.04.14 (4)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: MIRROR BRACKET

Job Number: 44122A

Part Number: D2161205

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/04/14 (CC)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

1:30pm

OVEN TEMPERATURE:

320°F

FINISH TIME:

2:00pm

JD 09-04-16

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

JK 09-04-16 (4)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/17 (A)

Job Completion



CY 09/04/17

PP44122

JS 09/04/17 (x4)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

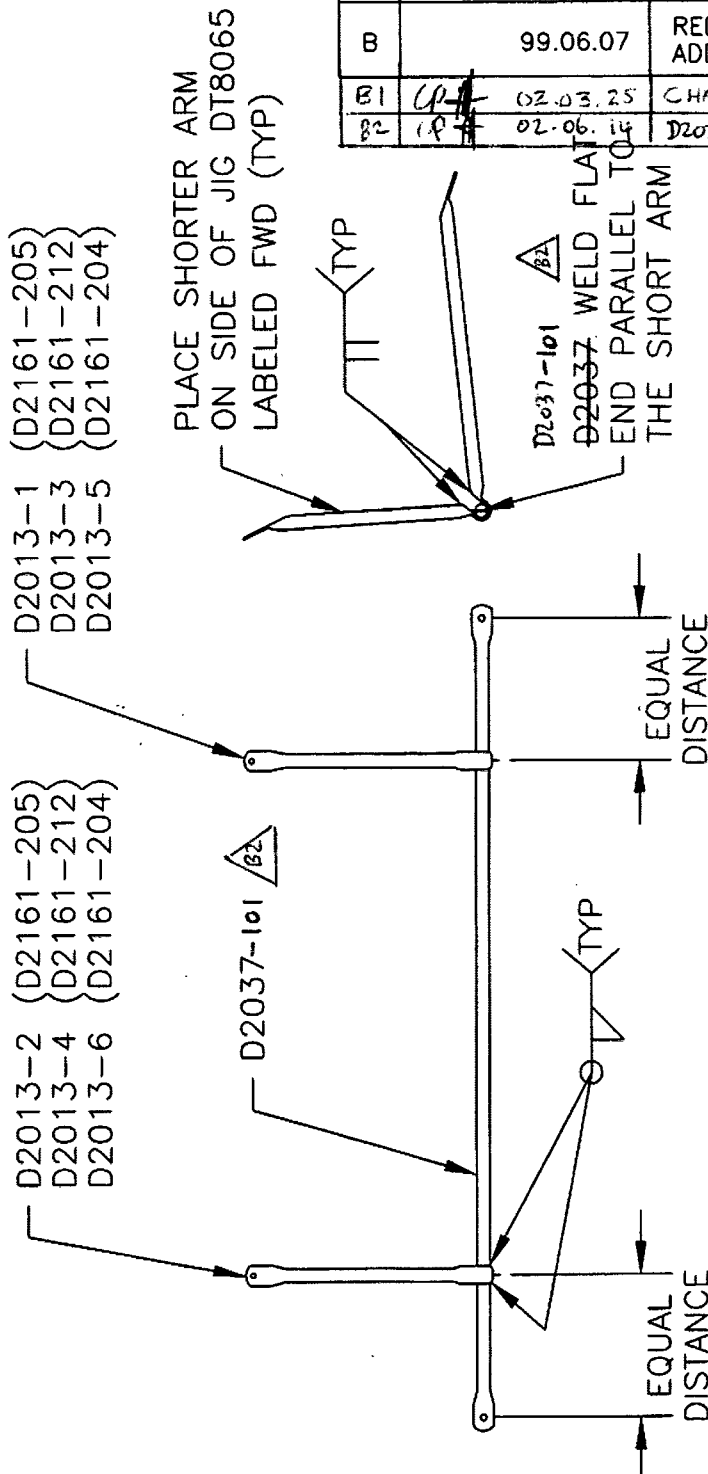
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	JB	DRAWN BY	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	RE	APPROVED	[Signature]	DRAWING NO.	REV. B
				D2161	SHEET 1 OF 1
DATE	99.06.07			TITLE	SCALE
				MIRROR BRACKET	NTS
A	93.04.29			NEW ISSUE	
B	99.06.07			REDRAWN FOR CLARITY ADDED -204/-205/-212 DESIGNATIONS	
B1	02.03.25			CHANGE FINISH	
B2	02.06.14			D2037-101 W/ D2037	

RELEASED
KE 99.06.10

DETAIL OF D2161-204
DETAIL OF D2161-205
DETAIL OF D2161-212

NOTE: WELD ASSEMBLY
USING JIG DT8065

FINISH: POWDER COAT ASSEMBLY BLACK
GRINKE (4.3.5.3) PER DART GSI 005 4.3
POWDER COAT BLACK SANDTEX (4.3.5.7) PER
DART GSI 005 4.3

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